

Ship 05/09

SLIT

Dart Aerospace Ltd.

Date: Wednesday, 20/08/2008 12:49:16 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COLLECTIVE LOCK
Job Number	: 41527 -1	Part Number	: D3372041
Estimate Number	: 11948	Drawing Number	: D3372 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 20/08/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL / MED FAB	Due Date	: 04/09/2008
Previous Run	: 32850	Qty:	4 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev:A Removed from 9 Digit 06-01-13 JLM Est Rev:B Added Key ID 06.03.21 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D27287	Label
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Decal 22554

SAD 08/09/07 4

2.0	D33721	Main Body
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3372-1 Main Body B4526

SAD 08/09/07 4

3.0	D33725	Cam Lock Shaft
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3372-5 Cam Lock Shaft B2290

SAD 08/09/07 4

4.0	D33727	Slider Body
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3372-7 Slider Body 22291

SAD 08/09/07 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 41527

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33731

Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description

1 D3373-1 Cam Lock

Keys alike keys dislike

B 420A43 B

22610

22944

26212

\*\*\*CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE\*\*\*

SAD 08/09/07

4

6.0

AN542A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5-42A Bolt 108 089

SAD 08/09/07

4

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 5/16WC SS Flat Washer 106 869

A/RN/ALocktite 262 1107 045

110138x2

SAD 08/09/07

4

8.0

D33841

Cyclic Sock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3384-1 Cyclic Sock 132172

SAD 08/09/07

4

9.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CBL-460 Loop Sleeve 1107234

SAD 08/09/07

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

CBL1240

Cable



Comment: Qty.: 0.6999 f(s)/Unit Total : 2.7997 f(s)

Pick:

Qty Part Number Description Batch

8" CBL-1240 Cable 24409

7103927

SAD 08/09/07

4

11.0

AN960416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-416 Washer 115519

SAD 08/09/07

4

12.0

HX81

1/4"-20 SHCS 3/8" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HX-81 1/4"-20 SHCS 3/8" long 16971

SAD 08/09/07

4

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372

Identify as D3372-3

SAD 08/09/07

4

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/09/07 (4)

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5

SAD 08/09/08 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 41527

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty Part Number Description Batch

A/R N/A Locktite 262 M107045

Identify as D3372-053

2-Assemble D3372-051 as per Dwg D3372. Identify as D3372-051 and attach keys Ensure that assembly locks and unlocks smoothly.

3-Assemble lanyard to cyclic sock as per Dwg D3384

SAD 08/04/08 (4)

4-Assemble D3384-043 to D3372-051 using 1/4"-20 socket head cap screw and washers as per Dwg D3371.

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack weld lock shaft as per Dwg D3372

Qty Part Number Description Batch

A/R N/A SS Rod

M106762

PC09-04-23 (2)

18.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD 09-04-23 (2)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/06/24 (2)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST486

SS 09/04/24 (2)

Record Keys alike #

Record Keys dislike #

C420A

C420A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 41527

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/28/08

Job Completion



u 09.04.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

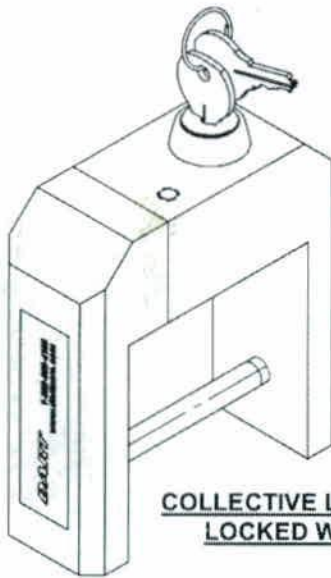
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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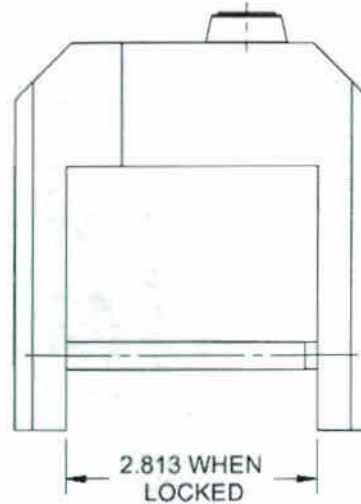


**DART**

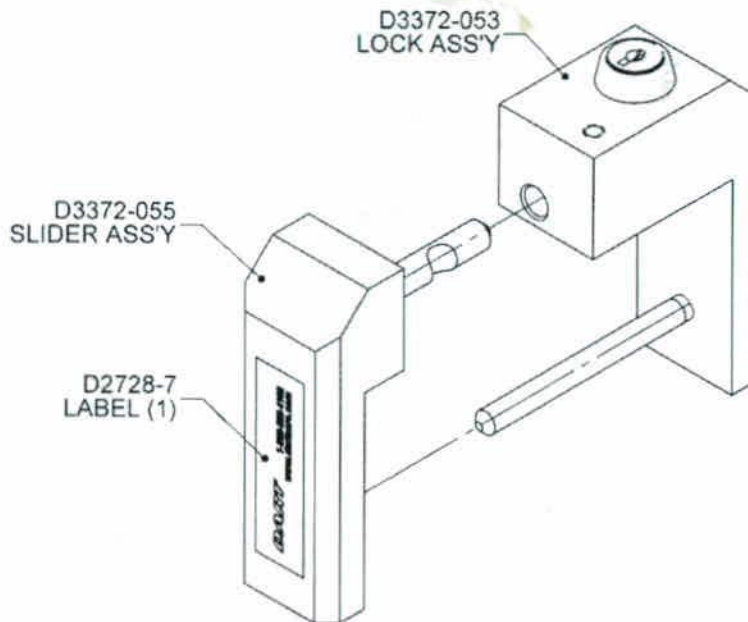
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CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE	05.02.23	TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS**



2.813 WHEN  
LOCKED



D3372-053  
LOCK ASS'Y

D3372-055  
SLIDER ASS'Y

D2728-7  
LABEL (1)

RELEASED  
05/04/28

W/O  
41527

**D3372-051 AS350 COLLECTIVE LOCK ASS'Y**

**NOTES:**

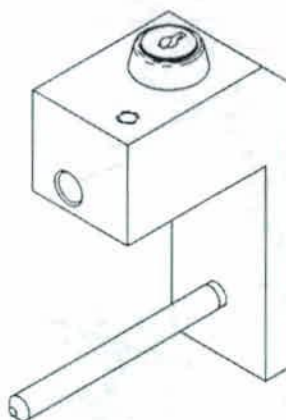
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- 2) ALL DIMENSIONS ARE IN INCHES

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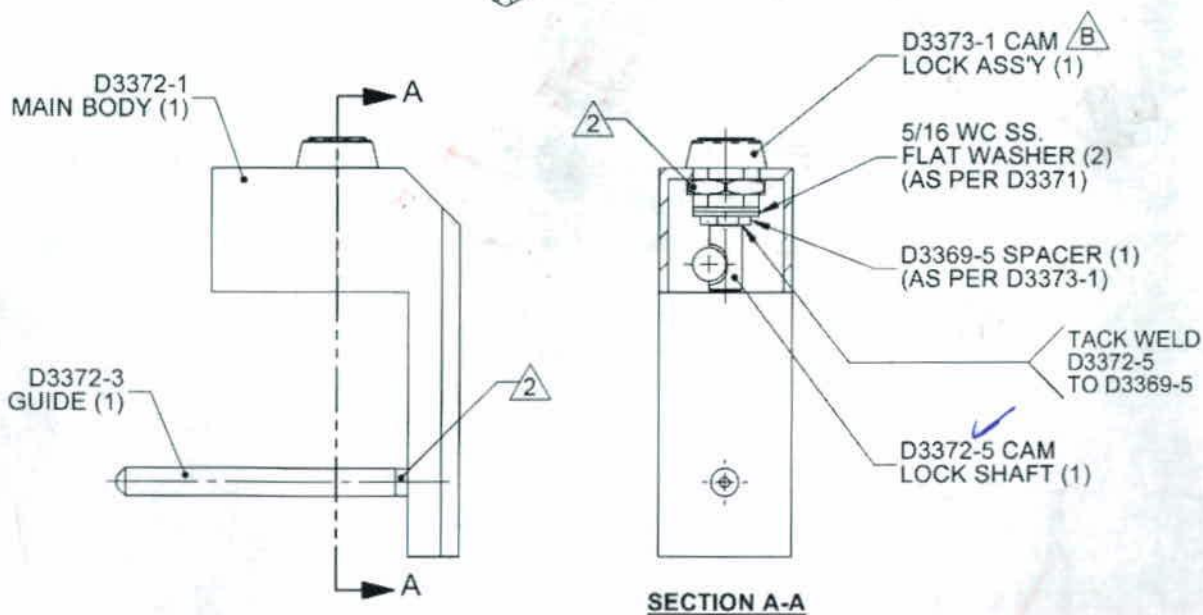
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 2 OF 8
DATE <b>05.02.23</b>	TITLE <b>COLLECTIVE LOCK</b>		SCALE 1:2



RELEASED  
*[Signature]*  
05/04/23



**D3372-053 LOCK ASS'Y**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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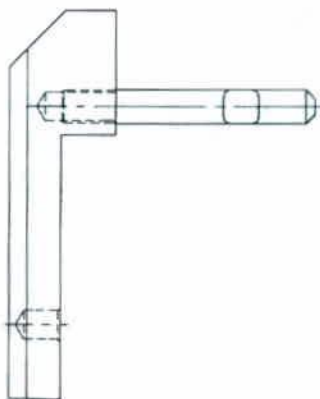
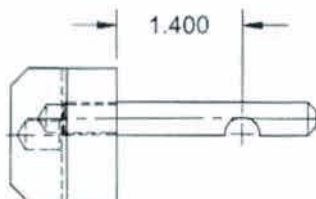
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41527

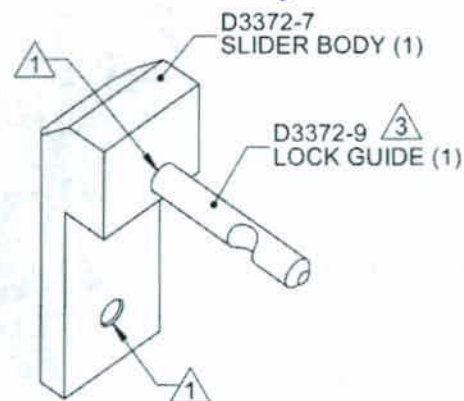


**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 3 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



RELEASED  
*[Signature]*  
05/04/23



### D3372-055 SLIDER ASS'Y

#### NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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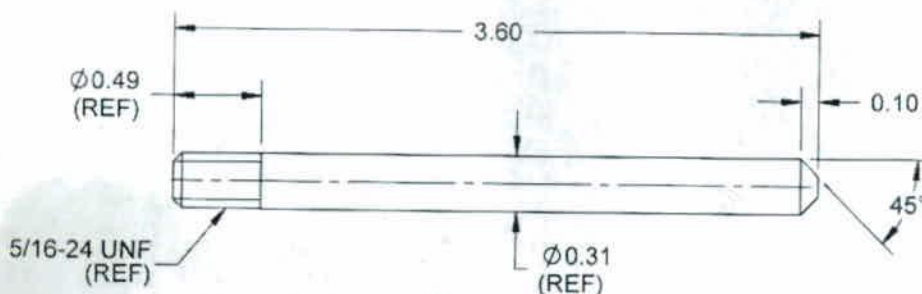
**DART**

DESIGN 13	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 17	APPROVED [Signature]	DRAWING NO. D3372	REV. B SHEET 5 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

## SPECIFICATION CONTROL DRAWING

RELEASED  
[Signature]

05/04/23



### D3372-3 GUIDE

#### NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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